

Date: Tuesday, 3/11/2008 9:58:22 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE ASSEMBLY
Job Number : 37769	
Estimate Number : 11053	
P.O. Number :	Part Number : D2873043
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2873 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37340	Material :
Written By : <u>JA 08 03 11</u>	Due Date : 3/25/2008 Qty: 30 Um: Each
Checked & Approved By : <u>JA 08 03 11</u>	
Comment : Est A 05.09.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR
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Comment: Qty.: 0.3237 f(s)/Unit Total : 9.7115 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B0.375x01.000)

Identify for D2873-3

Batch: M107244M107220-2 blanksSA

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 1.000" x 0.375" x 3.700" long

SA 08/03/15

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-3 Dwg Rev A Folio Rev AB.A./J.L 08/03/17

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B.A./J.L08/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 9:58:22 AM
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Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 08/03/19

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

ml 08/03/24 x30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4003-24

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

30
SK 08-03-25

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

x30
ml 08/03/27

10.0

MS20426AD46

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total: 180.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

M103395

W

11.0

MS21075L5

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 90.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

18136

8/3/26 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 9:58:22 AM
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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 37769

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

X27

ml 08/03/27

PTO

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/31 (27)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 10n 008

08/03/31 (27)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



mf 08-03-31

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2873-043 PAR #: N/A Fault Category: Prod / Eng. Ass. made to spec NCR: (Yes) No DQA: A Date: 08/04/04
 QA: N/C Closed: A Date: 08/04/04

NCR: 37769		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/26	12	Tried to Squeeze rivets with Tool, Some of Nut plate was lock. Scrap 3x D2873-3 Radu Block Scrap: 29 Nut plates and 58 rivets	<i>[Signature]</i> 08/04/04	J.L. made a new tool to fit. Replace 29 Nut plate M18136 58 rivets M105144 No replace D2873-3 <u>OK *3</u>	<i>[Signature]</i> 08/03/26	<i>[Signature]</i> 08/03/31	<i>[Signature]</i> 08/04/04	<i>[Signature]</i> 08/02/31

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37769
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

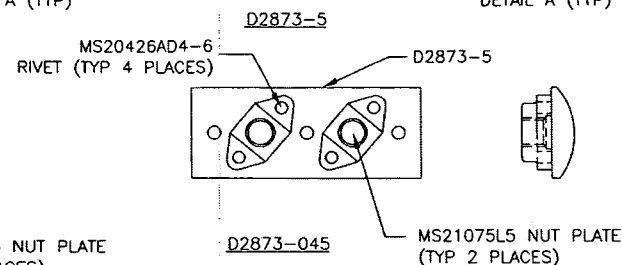
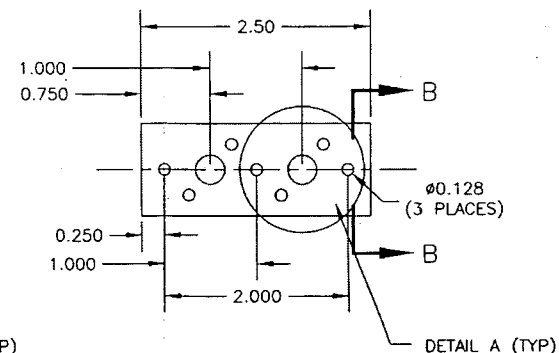
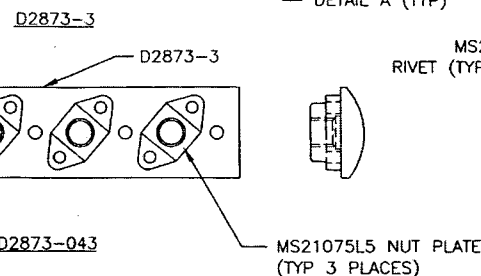
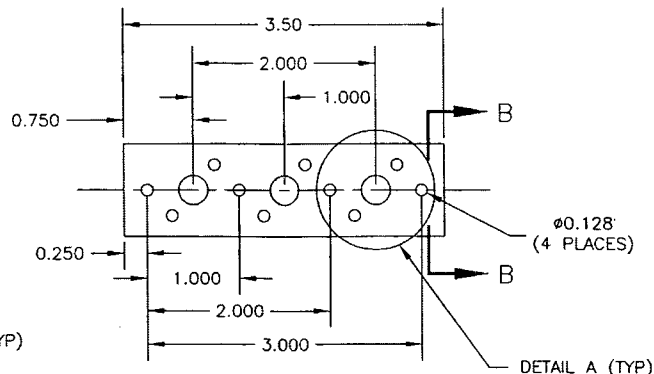
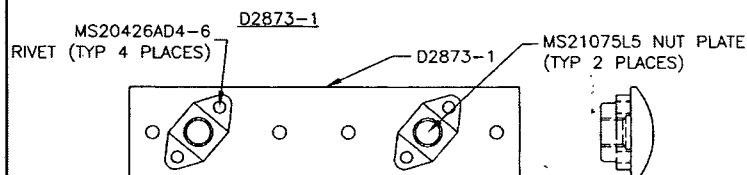
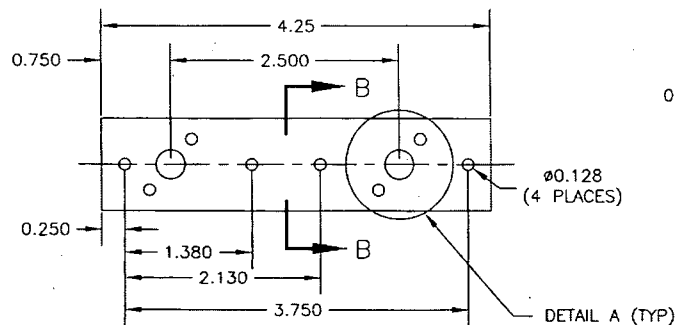
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓			
2.000	+/-0.010	1.999	✓			
0.750	+/-0.010	0.750	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	0.251	✓			
1.000	+/-0.010	1.001	✓			
2.000	+/-0.010	2.001	✓			
3.000	+/-0.010	3.001	✓			
Ø0.128	+0.005/-0.001	Ø.130	✓			
0.359	+/-0.010	0.360	✓			
Ø0.316	+0.006/-0.001	Ø.318	✓			
1.000	+/-0.010	1.003	✓			
0.250	+/-0.010	0.249	✓			
0.061	+/-0.010	0.060	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.233 x 0.125	✓			

Measured by: H.A.	Audited by: SA	Prototype Approval:	N/A
Date: 08/03/17	Date: 08/03/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	



D2873-041

D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

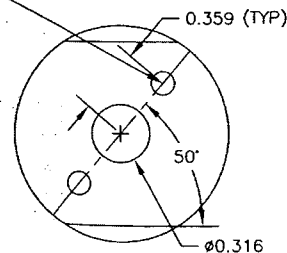
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X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

(-041 4 PLACES)
(-043 6 PLACES)
(-045 4 PLACES)

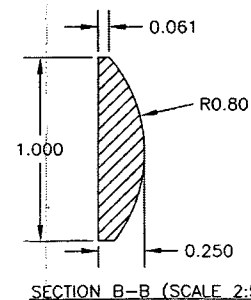
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WITHOUT NOTICE

NO. 27769

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RETURN TO
ENGINEERING
WORK ORDER



DETAIL A (SCALE 2:5)



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

